for processing of HELICOIL $^{\! 8}$ Plus Free Running with installation tools types: B-S 824 | E-S 410 | P-S 412 | P-S 1216

Type 4160.25 installation mandrel with depth stop to process HELICOIL® Plus Free Running coil thread inserts with fine or coarse thread.

Suited for:

- Type E-S 410 electrical installation tool
- Type B-S 824 cordless installation tool
- P-S 412 and P-S 1216 pneumatic installation tools

Properties:

• With external hexagon as per DIN 3126 - E 6.3/DIN ISO 1173

Noto:

These installation mandrels can also be used as manual installation mandrels.

HELICOIL® Plus Screwlock installation mandrels are marked with a ring groove on the guide shaft. HELICOIL® Plus Free Running installation mandrels have a smooth guide shaft.

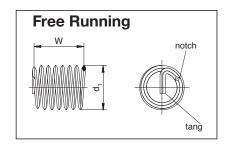
Technical information can be found on the last page.

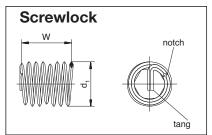
Diameter	Article number	Pitch	
(d)		(P)	Design
M 7	41602507020	1.00	HELICOIL® Plus Free Running
M 8	41602508020	1.25	HELICOIL® Plus Free Running
M 9	41602509020	1.25	HELICOIL® Plus Free Running
M 10	41602510020	1.50	HELICOIL® Plus Free Running
M 12	41602512020	1.75	HELICOIL® Plus Free Running
M 14	41602514020	2.00	HELICOIL® Plus Free Running
M 16	41602516020	2.00	HELICOIL® Plus Free Running
M 18	41602518020	2.50	HELICOIL® Plus Free Running
M 20	41602520020	2.50	HELICOIL® Plus Free Running
M 22	41602522020	2.50	HELICOIL® Plus Free Running
M 24	41602524020	3.00	HELICOIL® Plus Free Running



All technical data refer to the measure mm

HELICOIL® Plus thread inserts



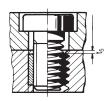


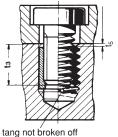
W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread

DHC D HC COO

Assembly





Prior to tapping, counter-bore 90° and deburr. Outside diameter of **countersink** = D_{HC} + **0.1** mm.

- d = Nominal thread diameter
- P = Thread pitch
- d₁ = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- D_{HC} = Outside diameter of the parent thread
- D_{1HC}= Crest diameter
- Suitable twist drill diameter. Please note:
 D_{1HC} is critical for selecting the correct twist drill diameter.
- t₁ = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t₂ = The nominal length of the thread insert corresponds to the minimum length of the full parent thread for blind holes or the minimum plate thickness for a through hole.
- t₃ = Maximum screw-in depth when the tang is not removed
- t_5 = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t_2 corresponds to the abovementioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values t_1 and t_2 .